

# Work Order ID 86084

June-20-12 12:57:19 PM

**\*86084\***

Page 1

Item ID: D2125

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: 350/355 Floor Window

Start Date: 20/06/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2125	Rev C
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100	FLOW WATER JET	0.00
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**\*100\***

Waterjet

Memo

0.00

2 0 Jun 12-6-24

FLOW CNC Waterjet

1-Cut as per Dwg D2125 Dwg Rev: C Prog Rev: C 2-  
Deburr if necessary

Poly Case 1/8

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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**\*110\***

QC

Memo

0.00

2 0 Jun 12-6-24

Quality Control

120	QC8- Inspect parts - second check	0.00
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**\*120\***

QC

Memo

0.00

2 0 Jun 12-6-24

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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**\*86084\***

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Item ID: D2125

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Start Date: 20/06/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

**\*160\***

Thermoform

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches as required

x2

12/02/08

170

**\*170\***

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

5/7/08/04

2

180

**\*180\***

Packaging

Packaging

0.00

Memo

0.00

Packaging

Wrap in cellophaneIdentify and StockLocation:

208

2x

Sp  
12-7-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 86084**

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**\*86084\***

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Item ID: D2125

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: 350/355 Floor Window

Start Date: 20/06/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

CK 12/7/6

MF  
12-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

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Page 1

Work Order ID: 86084

\*86084\*

Parent Item: D2125

\*D2125\*

Parent Item Name: 350/355 Floor Window

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: D05.10.14 Added bold comments on step 5/6 & cellophane on step 7KJ/EC

IPP E 07.05.29 thermoformed in-house EC

IPP F 07.09.28 rev C dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			120	sf	287.2590	1.664	3.503158			

**\*MACRLICS 125\***

1/8" Polycast II Sheet

\*\*

Jm 12-6-2

## Location

## Loc Qty

## Loc Code

MAT019

287.259

110633

3

117324

0.2467

117431

10.7967

119591

48.22

121850

224.9956

119951

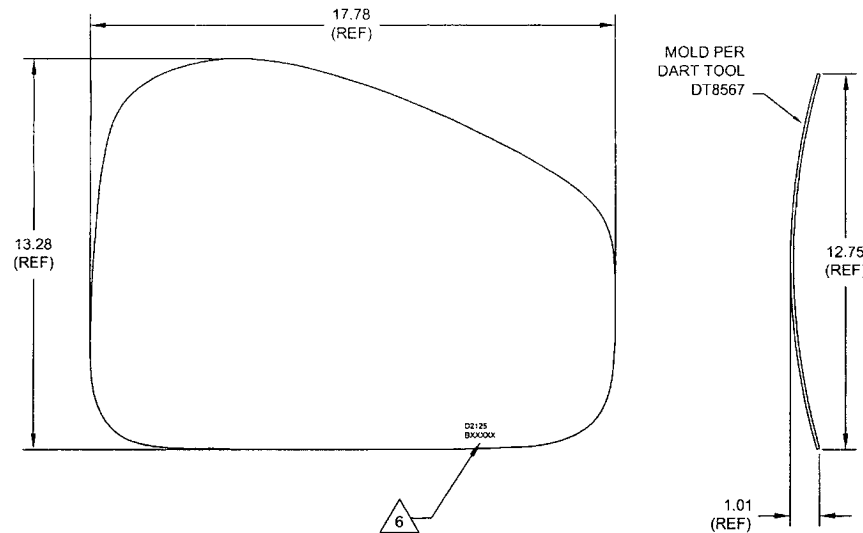
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**D2125 FLOOR WINDOW  
(FLAT TEMPLATE)**

**D2125 FLOOR WINDOW:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D2125" AND B/N ON LOWER EDGE  
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 0.98 +/- 0.22 LBS
- 8) FLAT ROUGH SIZE: 13.3 x 17.8 x 0.13
- 9) MOLD PER DART TOOL DT8567

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86084 MLO

12/06/20

RELEASED  
07.07.18

C	REDRAWN PER PAR 187	DC	07.07.18
B	CREATE DWG. UPDATE MTL PER NCR 029	MB	06.04.19
A	ADDED PICTURE WITH OVERALL DIMS	KE	99.03.09
-	NEW ISSUE	BW	92.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	JB	DRAWING NO.	REV. C
MFG. APPR.	JB	D2125	SHEET 1 OF 1
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	350/355 FLOOR WINDOW	NTS
DATE	07.07.18	COPYRIGHT © 1992 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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## FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	